

# Work Order ID 50787 - 1

July 22, 2009 12:47:35 PM

07/24/09

Page 1

Item ID: D3948-041

Revision ID: B

Item Name: Plate, Anchor

Start Date: 07/22/2009 Start Qty: 12.00

Required Date: 07/27/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-22

Tooling:

Date:

QC:



Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3948	B								
100		0.00							
									
Waterjet		0.00							
FLOW CNC Waterjet									
	<b>Memo</b>								
	1-Cut as per Dwg D3948-1								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC		0.00							
Quality Control	<b>Memo</b>								

1B 9-7-23

1B 9-7-23

(17)

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Item ID: D3948-041

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Start Date: 07/22/2009 Start Qty: 12.00

Required Date: 07/27/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

=> 502/07/23

(17) 0



QC

Quality Control

Memo

0.00

130



Small Fab

Small Fab

Memo

1- countersink holes as per dwg

2- deburr if necessary

0.00

0.00

SAD 09-07-24

(3)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

=> 502/07/24

(13) 0

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Item ID: D3948-041

Revision ID: B

Item Name: Plate, Anchor

Start Date: 07/22/2009 Start Qty: 12.00

Required Date: 07/27/2009 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD 09-07-24 (3)

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> S 07/4/04 (3) f

170

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SAD 09-07-24 (3) Qty



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Item ID: D3948-041  
Revision ID: B  
Item Name: Plate, Anchor

Accept



Setup Start



Stop



Start Date: 07/22/2009 Start Qty: 12.00  
Required Date: 07/27/2009 Req'd Qty: 12.00



Cust Item ID:  
Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



Small Fab

Small Fab

Memo

INSTALL NUT PLATES AS PER DWG

0.00

SAD 09-07-24 3<sup>rd</sup>

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 8 02/24/24

(X3) 6

200



Packaging

Packaging

Identify as per dwg & Stock Location: 139

Memo

0.00

0.00

164/24 (3)

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Item ID: D3948-041

Accept



Setup Start



Revision ID: B

Item Name: Plate, Anchor

Stop



Start Date: 07/22/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 07/27/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/07/27 *[Signature]*

*MF 09-07-24*

# Print

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Page 1

Work Order ID: 50787



Parent Item: D3948-041RevB



Parent Item Name: Plate, Anchor

Start Date: 07/22/2009

Required Date: 07/27/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

135.2173

1.3705



6061-T6 .063 Sheet

Warehouse

Loc Qty

Loc Code

1.94

Location

Main Warehouse

MAT

135.2173316

109463

0.6447

110551

134.572632

MS21059L3

Purchased

No

170

Each

839.0000

24.0000



Nut Plate

110551

18 9-7-03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

839

109962

339

111925

500

MS20426AD3-3

Purchased

No

170

Each

8,118.000

48.0000



Rivet

6

SAD 09-07-24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8118

1563

0

19099

4776

7681

3342

12

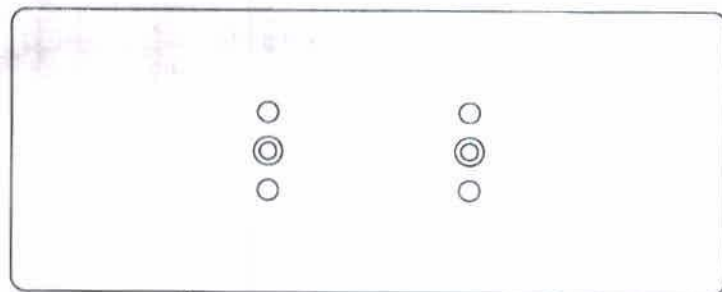
SAD 09-07-24





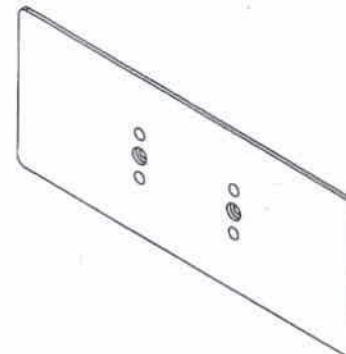
## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

**D3948-041 PLATE, ANCHOR**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

RELEASED  
07/26/16

50787

B	-3F NOW MADE FROM 304 SS (ZN AB-5), 0.003 THICK WAS 0.040 (ZN AB-3, AB-5), -043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEW ISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.08		

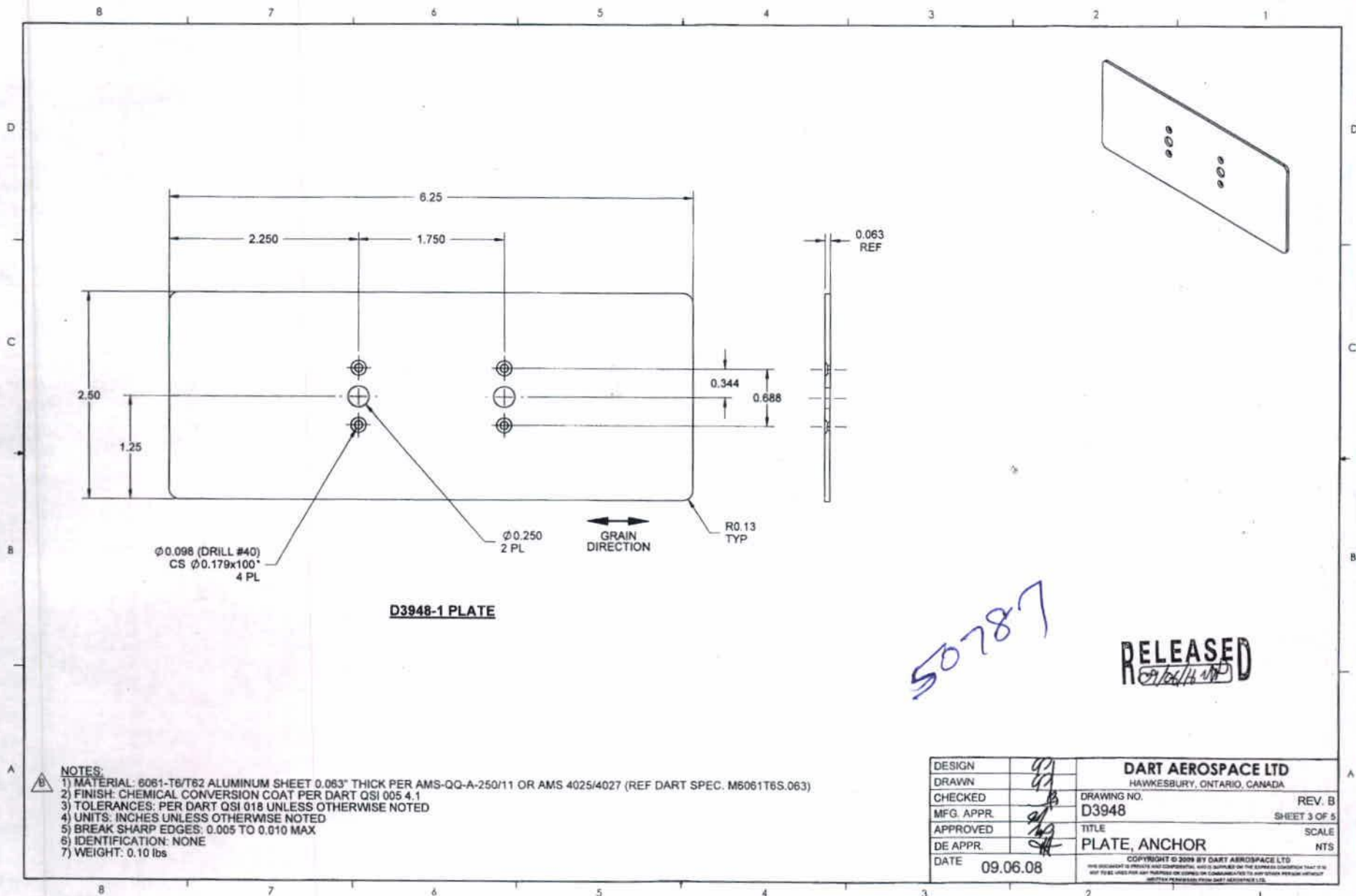
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3948** REV. B  
SHEET 1 OF 5

TITLE **PLATE, ANCHOR** SCALE NTS

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50787  
**RELEASED**  
9/24/14

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
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